Work Orde May-13-13 1:15		1834 —			834*						Page 1
Item ID: Revision ID: Item Name:	D2230-1		5 Pit 120	Accept	*N900	040	100)* s	etup Sta	1 \	S1* S2*
Start Date: Required Date:	5/13/13 5/31/13	Start Qty: 320.00 Req'd Qty: 320.00			Cust Item I Customer:	D:			·		
Reference: Approvals:	Drones Die	CJ	Date: \\3/05/14	Tooling	D:	ate:	-	R	Run Sta	rt *N	IR1*
Approvais.				SPC (Y/N):		ate:			Sto	^p *N	IR2*
Sequence ID/ Work Center II	 D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr									
D2230	Rev	/ G									
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut D2423 of Batch:	extrusion to 0.82" - Wetac	0.00				_CX) 13/os	5/14	3 <u>20</u>
110 HAAS I PER	al machine #1	DWG REV FOLIO REV (Check for o	per folio FA927	0.00 .0.00 machine.)				CX	13/05//	Y_3	<u>20</u>
		2- deburr ro	abus 710	to mete er deg	10 22 30 1	REU.(1				

NCR: Ye	es / No				WORK ORDER NON-CONFORMANCE / UPDATE				ATE	QA Closed:	Date	e:
Work Order	:				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No)				Rework Scrap		ı	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR No	D			.	Use-as-is Work Order Update]		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descri	ption of work order update	lni	itial	Acti	on	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chie	f Eng	Descri	ption	Date	Verification	QC Inspector
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quip/Tooling												-
perator	_											
faterial	_	Í										
etup												
ther												
rocess	_											
upplier	_											
raining	4	1										
Inapproved		<u> </u>				<u> </u>					<u> </u>	
1	- 0	·				AULI	CATE	GURY			W	
Landing	 ,			<u></u>	General		Grain			Ovalized	Г	Pressure/Forced
-	Bending	- + C		\(\begin{array}{c} \begin{array}{c} \end{array}	Bend BOM/Route	\mathbf{H}	arain Iardwa		-	Ovanzed Over/Under	toloranco	Temperature/Cure
-	Centre N Cracks	ot Conce	ntric to), -	Broken/Damaged	_		on Incomplete	 	Part Incorred	F	Weld
}	Crushed/	Crimped		⊢	Burrs	-	•	ions Incomplete/U	nclear	Part Lost/Mi		Wrong Stock Pulled
F	Cuffs	Cillipeu		}	Contamination	$\boldsymbol{\vdash}$		enance	- Inclear	Part Moved	331116 [vvrong stock r diled
F	Heat Tre	at			Countersink	-			-	Positioned V	Vrong	
-	Inspection		Tube	 	Cut Too Short	\vdash	Mislabeled Misread		—	Power Loss/		Other
<u> </u>	Ripples in		· abc		Drill Holes	Offset			1. 21.0. 2000)		1	
 	→ ''	Vaves in 1	extrusio	,	Drawing	Out of Calibration						
<u> </u>		Sequence		·	Finish	Out of Seque						
<u> </u>	Wave/Tv				Folio			Dimensions				

DQA:

Date:

Work Orde May-13-13 1:15		101834		*1018	834*	<u></u>					Page 2
Revision ID:	D2230-1		A	ccept	*N900	040	100	* S	Setup Star Stop	IVI	S1* S2*
Start Date: Required Date: Reference:	5/13/13 5/31/13	Start Qty: 320.00 Req'd Qty: 320.00	*320* *320*		Cust Item II Customer:	D:					
Approvals:	Process QC:	Plan:		Tooling: SPC (Y/N):		ite:		F	Run Star Sto _l	''IV	R1* R2*
Sequence ID/ Work Center II 130 * CONTROL QC Quality Control		Operation Description C2 Inspect parts off ma	tooger	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control		QC\$-Inspect parts - secon	•	0.00 B 6 1	4		(120 San)	· <u></u> -	
*1 4 0		Chemical Conversion Co	at per QSI005 4.1	0.00				121	0 7	B13	617

0.00

Memo

140 HandFinish

Hand Finishing

NCR: Y	'es	/ No					WORK ORDER NON-C	O	NFORM	ANCE / UPE	DATE		•			1 .
												(QA Closed:	Dat	e:	
Nork Orde	er: _					۱	DISPOSITION	-	:		AGAINST D	DEP	PARTMENT	PROCESS		
Part N	lo						Rework Scrap Use-as-is		ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR N	lo						Work Order Update			Large Fab	Composite			Supplier		
Root					Desc	rip	tion of work order update	1	nitial	Acti	ion		Sign &			-
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Descr	iption	\perp	Date	Verification		QC Inspector
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***************************************							F	AUL	T CATE	GORY						
Landir	ng G	ear					General		_		_			_		_
		Bending					Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to	o/s		BOM/Route	L	Hardwa	re			Over/Under	tolerance		Temperature/Cure
	'	Cracks			L		Broken/Damaged		Inspect	on Incomplete			Part Incorred	et [Weld
		Crushed/0	Crimped		L		Burrs		Instruct	ions Incomplete/L	Inclear	\Box	Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs			L		Contamination		Mainte	nance		\sqcup	Part Moved			
-		Heat Trea	it		_		Countersink	L	Mislabe	led		_	Positioned W	· · ·		•
	-	Inspection	-	Tube	L	_	Cut Too Short		Misread	I	Ĺ		Power Loss/S	Surge		Other
. ·	-	Ripples in					Drill Holes	<u>_</u>	Offset							
		Torque W	/aves in E	xtrusio	n L		Drawing		Out of 0	Calibration		_				
		Turning S	equence				Finish		Out of 9	Sequence						

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Work Ord <i>May-13-13 1:</i>		01834		*101	1834*						Page 3
Item ID: Revision ID:	D2230-1	and a summer of the summer of		Accept	*N900	040 ′	100³	k Setup	Start Stop	*NS	S1*
Item Name: Start Date: Required Dat Reference:	Lug 5/13/13 e: 5/31/13	Start Qty: 320.00 Req'd Qty: 320.00	*320 *320		Cust Item II Customer:	D:				"IN:	S2*
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):		ite:		Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center 150 *150* QC Quality Control		Operation Description Octol Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID			Accept Re Qty Qt		Reject Number	Insp. Stamp
*160 *160* Powdercoat Powder Coating	620	White Gloss(Ref:4.3.5.1) Memo START TIME OVEN TEME FINISH TIME	7 / 3 C PERATURE: _ 32.	0.00			126	ΧØ	M	f_	13/06/

120 \$ 136-21.

0.00

0.00

170

*17**0***

Quality Control

QC3- Inspect Part Finish

Memo

		•							DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	ONFOR	MANCE / UP		QA Closed:	Date:	•
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	•				Rework Scrap Use-as-is Work Order Update	Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data								<u>_</u>			
Equip/Tooling											
Operator						 				ļ	
Material	7										•
Setup]										
Other	7										
Process						İ	<u> </u>				
Supplier											
Training	7		ļ								
Linapproved		1		ł		1			1		

Landing Gear General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Positioned Wrong Heat Treat Countersink Mislabeled Other Power Loss/Surge Inspection Strip in Tube **Cut Too Short** Misread Drill Holes Offset Ripples in Bend Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish Outside Dimensions Wave/Twist in Tube Folio

FAULT CATEGORY

Work Orde <i>May-13-13 1:15</i>		1834		*101	1834*						Page 4
Item ID: Revision ID: Item Name:	D2230-1		A	ccept	*N9000	ገ4በ1	ሰ ሰን	k Setup	Start Stop	*NS	\$1* \$2*
Start Date: Required Date: Reference:	5/13/13 5/31/13	Start Qty: 320.00 Req'd Qty: 320.00	*320* *320*		Cust Item ID Customer:) :		*			
Approvals:	Process Pla	in:		Tooling: SPC (Y/N):	Dat	e:		Run	Start Stop	*NF	
Sequence ID/ Work Center II 180 *180* Packaging Packaging	D	Operation Description Identify as per dwg & Stoo Memo	k Location: DX -DGA DX 57469	Set Up/ Run Hours 0.00	Tool ID		Code (Qty Qt	y 1	Number	Insp. Stamp ?-06-28
190 *1 QO* QC Quality Control		QC21- Final Inspection - \ Memo	Work Order Release	0.00			 		3/-	7/2 C	D 1-2.

												DQA:	Dat	te:	
NCR: Y	es /	No				WORK ORDER NON-	CON	IFORM	AANCE / UP	DATE	c	QA Closed:	Dat	te:	
Work Orde	r:					DISPOSITION				AGAINST D	EP	ARTMENT	/PROCESS		
Part N NCR N	o					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite Initial Action Chief Fing Description					Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	lı lı	ì				Sign &			
Cause	D	ate	Step	Qty		or Non-conformance	Chi	Chief Eng Description			Date	Verification	n	QC Inspector	
oc/Data quip/Tooling Derator Material etup Other Process Supplier						,									
Inapproved				L			FAUI.	T CATE	GORY				<u> </u>		
Landin	ng Gear					General		LT CATEGORY							
	Ben Cen Cra Cru Cuf Hea	ding tre No cks shed/ fs t Trea			o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread				Ovalized Over/Under Part Incorrect Part Lost/Mi Part Moved Positioned V Power Loss/	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Inst	ectio	n Strip in	rupe	L_	Trut 100 Short		Misread				ower Loss/	onige	لــــا	omer

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

`May-13-13 1:15:15 PM

Work Order ID:

101834

Parent Item:

D2230-1

Parent Item Name:

Lug

Start Date: 5/13/13

Required Date: 5/31/13

Start Qty: 320.00

Required Qty: 320.00

Comments:

IPP D00.11.01Added inspection level 8, and removed P/O for powder coatEC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1P		Purchased	No				Each	0.0000		320		1.1.0	(In
LUG											1-93	14/15	
D2423		Manufactured	No			110	f	588.7400	0.0683	23.00630	4 , 4,	- - / /	
Lug Extrusion											(1×1)	3/03/	4
				Location		Loc Qty	<u>Lo</u>	c Code					
				MAT006		383							
				4372	2	161.5							
				8795	3	221.5							
				Metec		205.74							
				9355	1	205.74				3.006)		

Page 1

NCR: Yes / No

DQA:

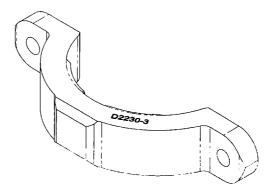
Date:

NCR: Y	·											
										QA Closed:	Date:	
Work Orde	r:				DISPOSITION	_	-		AGAINST D	EPARTMENT,	/PROCESS	
Part N	o				Rework Scrap		ſ	Skid-tube Machining	Crosstube Small Fab	⊣	Water Jet d. Eng. Coor.	Engineering Quality
NCR N	0				Use-as-is Work Order Update	╛┃		noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root				Descr	iption of work order update	Ir	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	QC Inspector
Ooc/Data quip/Tooling	-				,				* 4			ı
Operator Material												
Setup												
Other												
Process	7						ı					
Supplier	7					İ						
raining						ŀ						
Jnapproved												
						FAULT	CATE	GORY				
Landin	g Gear			_	General				_	_	_	_
	Bending				Bend		Grain			Ovalized	<u> </u>	Pressure/Forced
1	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa	re	L	Over/Under	tolerance	Temperature/Cure
1	Cracks			<u> </u>	Broken/Damaged		Inspecti	on Incomplete	L	Part Incorre	ct	Weld
Į.	Crushed/	/Crimped		L	Burrs		instruct	ions Incomplete/l	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
1	Cuffs			<u> </u> _	Contamination	Ш	Mainte	nance	ļ	Part Moved		
	Heat Tre	at			Countersink		Mislabeled			Positioned V		7
	Inspection	n Strip in	Tube		Cut Too Short		Misread				Surge	Other
	Ripples in	n Bend			Drill Holes	Offset						
	Torque V	Vaves in I	Extrusio	n	Drawing	Out of Calibration						
	Turning S	Sequence	!		Finish	Out of Sequence						
	Wave/Tv	vist in Tu	be		Folio	Outside Dimensions						

D2230-1



0213/05/14 w10: 101834



D2230-3 MOUNTING LUG



REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION. 09.01.16 REDESIGN; R1.200 WAS 1.100 99.12.13 RE-DESIGN Ε BW 95.01.04 D RE-DESIGN BW 95.01.04 С RE-DESIGN 94.03.30 BW DESCRIPTION BY DATE

DESIGN	вуу	DART AEROSPA	CELTD
DRAWN	AJKS	HAWKESBURY, ONTARIO	
CHECKED	1	DRAWING NO.	REV. G
MFG. APPR.	Graff.	D2230	SHEET 1 OF 3
APPROVED	M	TITLE	SCALE
DE APPR.	'- #	MOUNTING LUG	NTS
DATE OO	11 16	COPYRIGHT © 1994 BY DART AS	

NOTES:

1) MATERIAL: MAKE FROM D2423 EXTRUSION

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

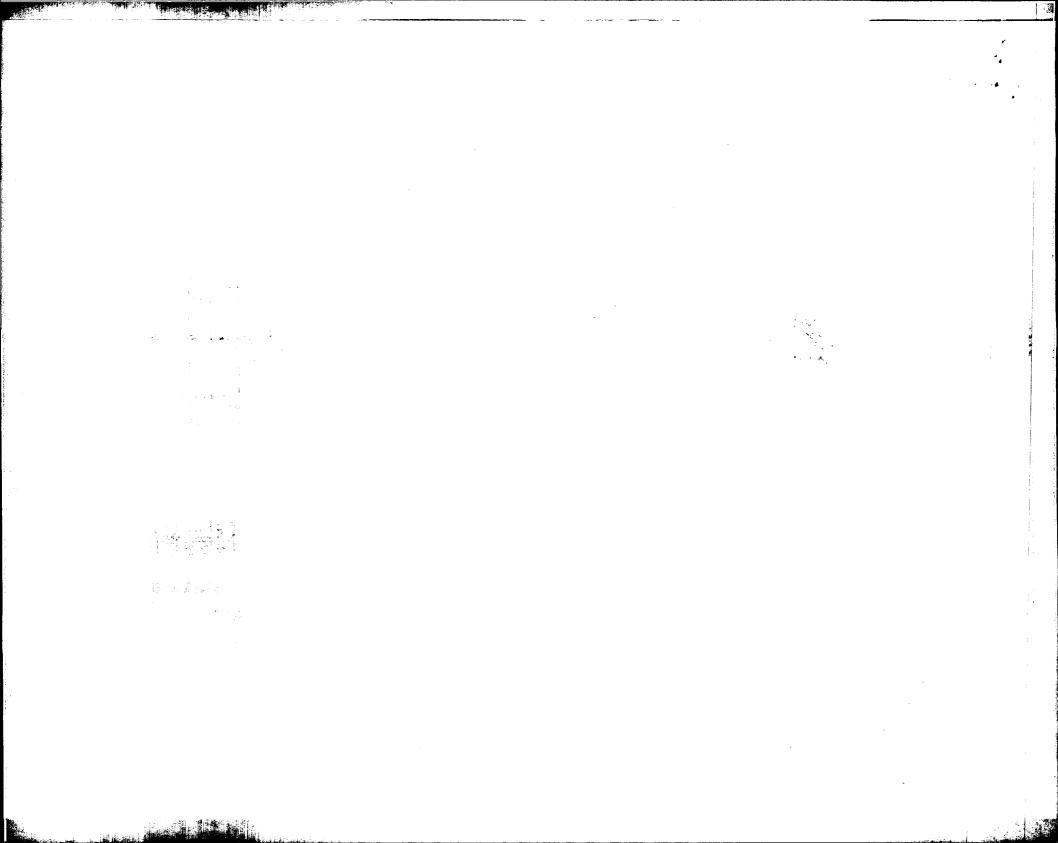
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

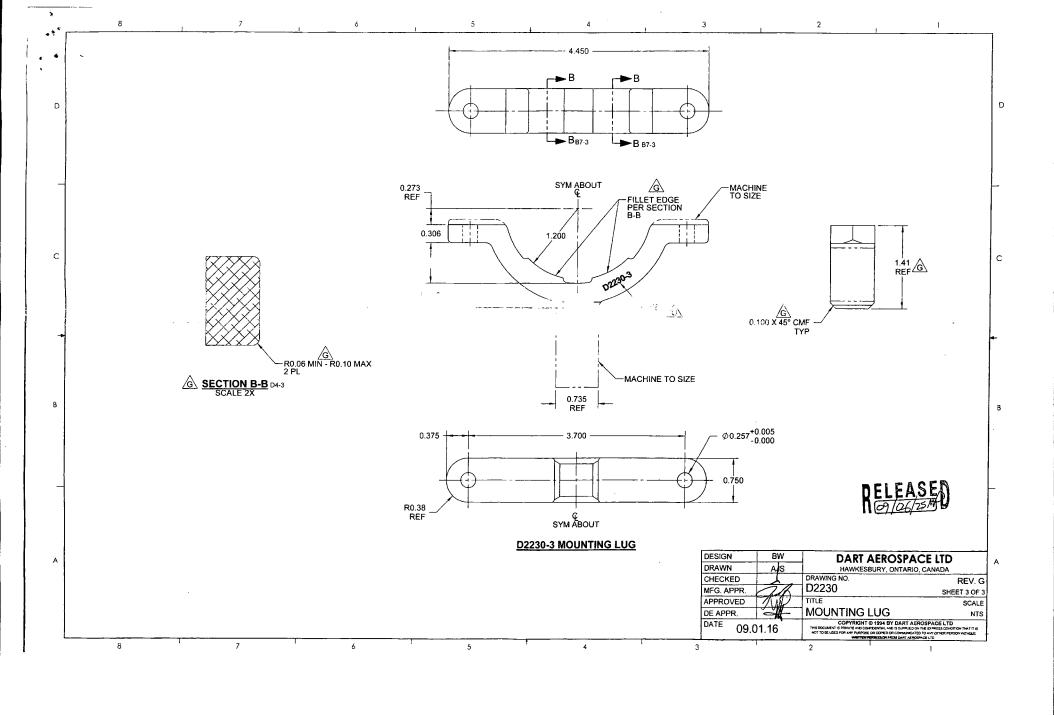
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ±0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.014.40 006 OF 0.015±0.005. 7) WEIGHT: -1: 0.16 lbs

-3: 0.14 lbs







20 Terry Fox Drive Vankleek Hill, Ontario K0B 1R0 , Canada

Tel: (613) 678-3957 Fax: (613) 678-3956

Delivery Slip No.:

19068

Date:

Jun 11, 2013

Page:

1

Thank you for your order!

Sold to:	Ship to:	Ship to:		
Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Att	art Aerospace Ltd. t. Linda Lacelle 270 Aberdeen Street awkesbury, Ontario K6A 1K7		
Order No.: 19868	Sold By:	Dewar, Eric		
Shipped By: your truck	Ship Date:	Jun 12, 2013		

110	A Description	Unit	Ordered guantity	Shipped quantity	Backorder quantity
D2230-3	Mounting Lug as per drawing D2230 REV.G , B101450	Each	300	· · · · · · · · · · · · · · · · · · ·	A STATE OF S
D2230-3	Mounting Lug as per drawing D2230 REV.G, B101495	Each	300		
D2230-1 B101834	Mounting Lug as per drawing D2230-1 REV.G,	Each	320	120	
D3235-1 B101559	Mounting Lug as per drawing D3235-1 REV.A,	Each	200		
should there be	goods must be inspected upon receipt to confirm compliance. e discrepancies please notify METEC within 30 days of delivery. otherwise deemed accepted.				·

	The Administration of the Administration of				L. M. Sand
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20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

SHIPPED TO:

Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, Ont.

same

K6A 1K7

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

120

D2230-1

Lug

PO 19868

MATERIAL: supplied by DART B93551

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, June 12, 2013